

Work Order ID 149188 - 2 split.

149188

Page 1

Thursday, July 21, 2016 10:54:35 AM

Item ID: D4634-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Middle, Center Ceiling Panel
 Start Date: 7/21/2016 Start Qty: 200 *2*
 Required Date: 7/28/2016 Req'd Qty: 200 *2*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: 2m Date: 16/01/21 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								DAS 07 9-89
100	HAND FINISHING THERMOFORMING	0.00							
100									
Thermoform	Memo	0.06				2			16/08/18
Thermoforming Machine	Cut Blanks								
105	Dry Material	0.00							DAS 07 9-89
105									
HandThermo	Memo	0.00				2			16/08/18
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE								
	Temp: 245 deg. F								AUG 17 2016
	Time IN: 5:00 PM								Per....
	Time OUT: 6:00 AM								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By 03 072	
				Lead hand / Supervisor Approval Verification 8-83 03 072	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER :			

Work Order ID 149188

Thursday, July 21, 2016 10:54:35 AM

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Page 3

Item ID: D4634-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Middle, Center Ceiling Panel
Start Date: 7/21/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/28/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Dimensional Inspection Memo Fill out Inspection Sheet Rev. A	0.00 0.00				2			DAS 07 9-89 16/09/08
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01							DAS 27 9-89 SEP 29 2016
160 *160* Packaging Packaging	Packaging Memo	0.00 0.00		w/c 149111		1			DAS 07 9-89 16/09/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 149188

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Page 4

Item ID: D4634-3**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Middle, Center Ceiling Panel**Start Date:** 7/21/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 7/28/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.03

Quality Control

**DAS
21
9-89**

SEP 29 2016

dem 16/09/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, July 21, 2016 10:54:34 AM

Page 1

Work Order ID: 149188

149188

Parent Item: D4634-3

D4634-3

Parent Item Name: Middle, Center Ceiling Panel

Start Date: 7/21/2016

Required Date: 7/28/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM
Dwg Update DL verf: DD
DL
DL
DL
IPP Rev B
IPP Rev C 13/07/09
IPP Rev D Dwg Update 13/12/23
IPP REV E Dwg update 14/01/09
IPP Rev F Dwg. update 14/02/03
IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	380.9000	17.33	34.66			DAS 07 9-89

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

Location

MAT023

m129738

m135302

Loc Qty

380.9

380.9

Loc Code

34.66 sq ft.

16/08/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :					

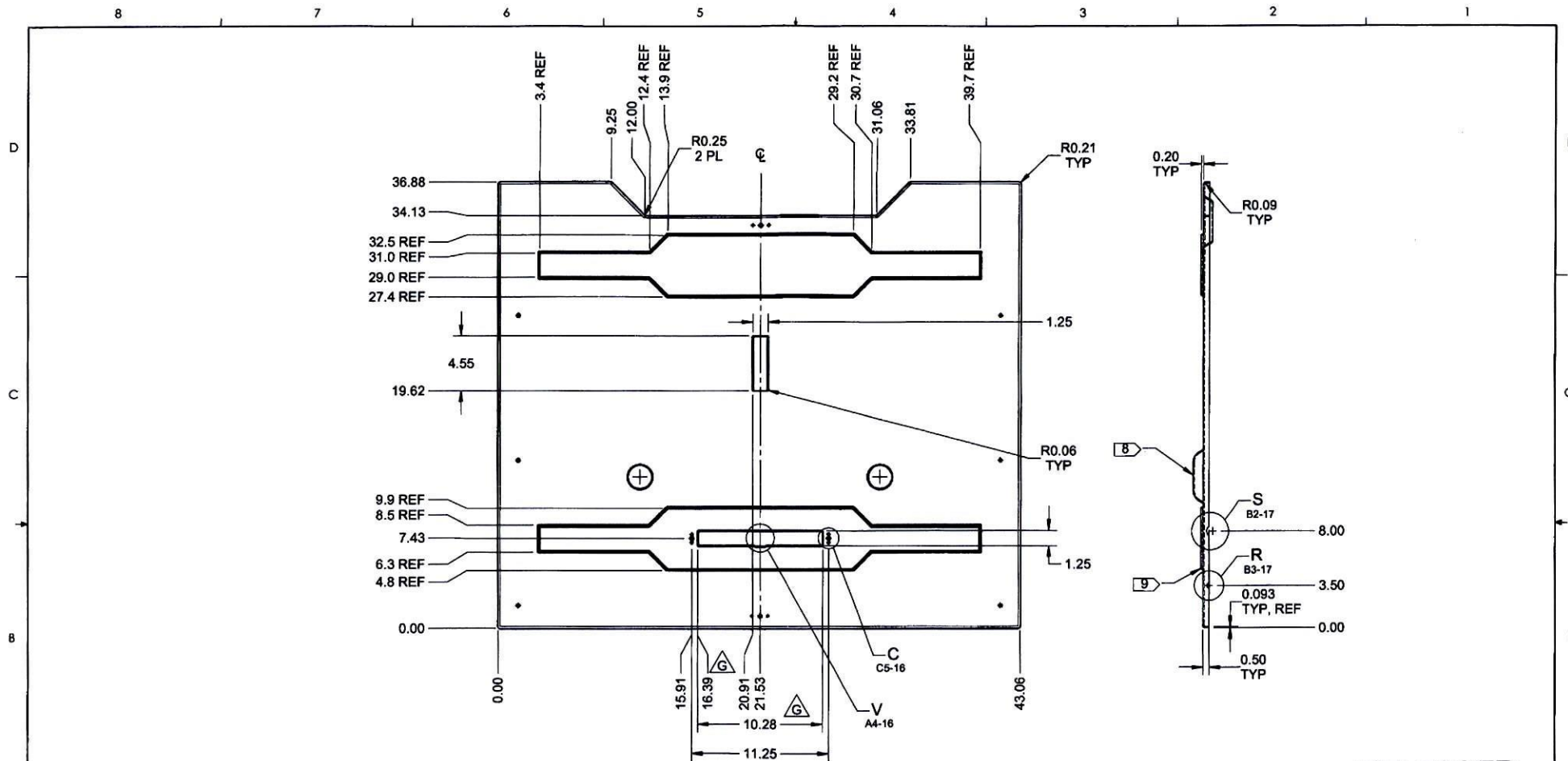
DART AEROSPACE LTD		Work Order:	K9188
Description: Middle Center Ceiling Panel		Part Number:	D4634-3
Inspection Dwg: D4634	Rev: FG 08	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.91	+/-0.030	15.93"	✓			
10.20	+/-0.030	10.20"	✓			
11.25	+/-0.030	11.25"	✓			
1.25	+/-0.030	1.23"	✓			
4.55	+/-0.030	4.55"	✓			
1.25	+/-0.030	1.25"	✓			
21.53	+/-0.030	21.53"	✓			
24.00	+/-0.030	24.00"	✓			
12.00	+/-0.030	12.00"	✓			
39.75	+/-0.030	39.75"	✓			
1.300	+/-0.010	1.3"	✓			
Ø0.250	+0.005/-0.001	Ø0.250"	✓			
Ø0.129	+0.005/-0.001	Ø0.129"	✓			
Ø0.250	+0.005/-0.001	Ø0.250"	✓			
Ø2.030	+0.012/-0.001	Ø2.03"	✓			
Ø0.250	+0.005/-0.001	Ø0.25"	✓			
0.688	+/-0.030	Ø0.69"	✓			
Ø0.098	+0.004/-0.001	Ø0.098"	✓			
0.344	+/-0.010	0.0345"	✓			
0.50	+/-0.030	0.51"	✓			
3.50	+/-0.030	3.5"	✓			
8.00	+/-0.030	8.0"	✓			

Measured by:	DAS 07 9-89	Audited by:	DAS 27 9-89	Preliminary Approval:	
Date:	16/09/08	Date:	SEP 29 2016	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	



NOTES:

1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 6.49 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-3 PER TOOL DT9837

11) THERMOFORM PER QSI 022 USING DT9845 TOOL

MIN. THICKNESS AFTER FORMING:

EDGES = 0.060

ELSEWHERE = 0.070

12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-3 MIDDLE, CENTER CEILING PANEL

RELEASED

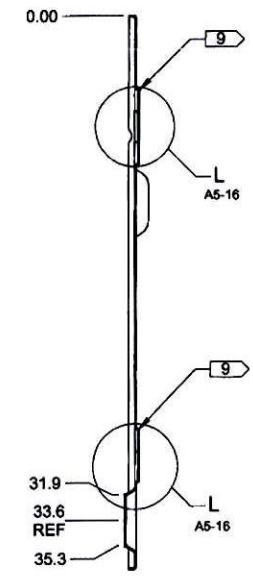
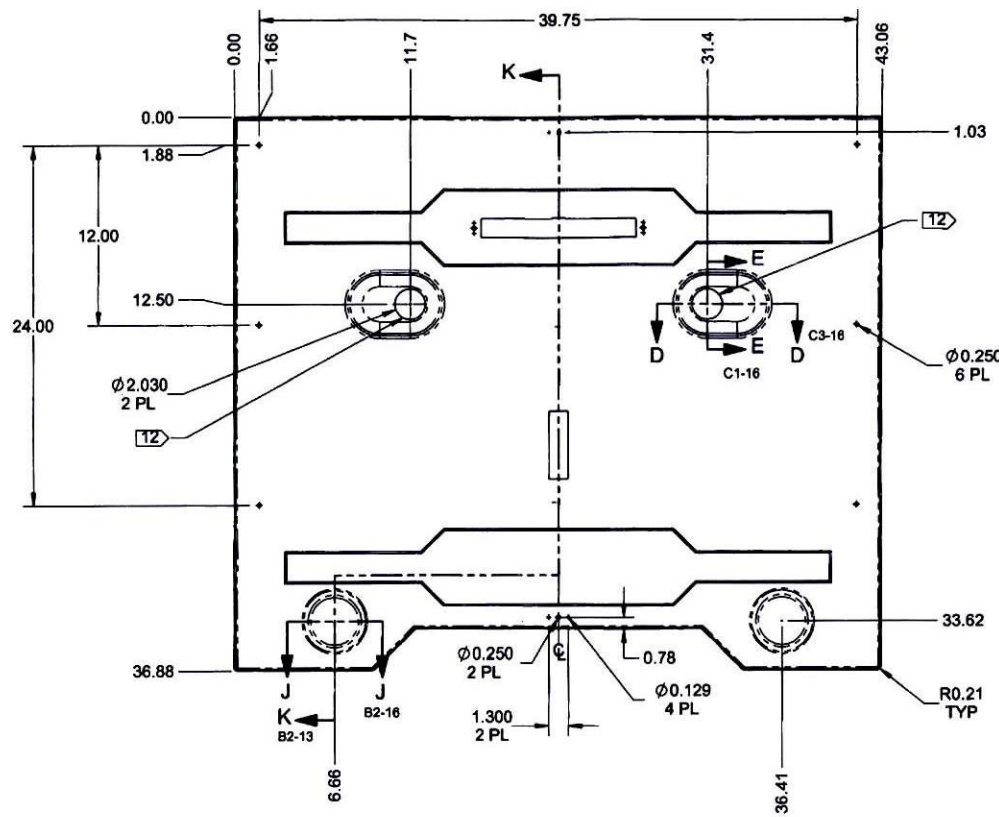
2015 JAN 26

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 12 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

w/o 149188

2m 16/07/21

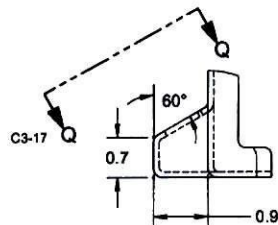


D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

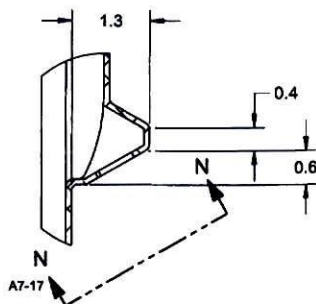
SECTION K-K B6-13

RELEASE
2015 JAN 26 *up*

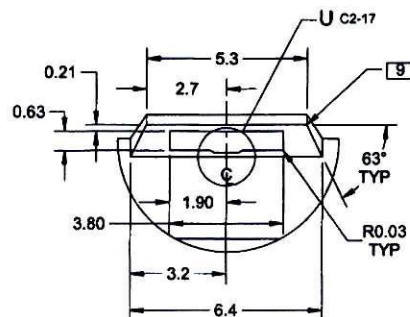
APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO. D4634	REV. G
	MFG. APPR.	DL	SHEET 13 OF 17	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE 14.11.28			COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



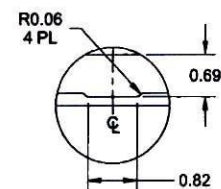
DETAIL P B3-14
SCALE 2X



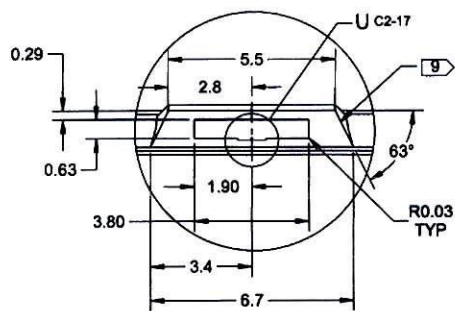
DETAIL M C3-10
SCALE 2X



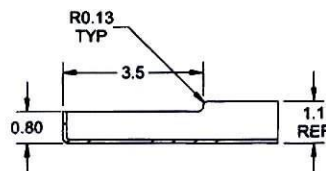
DETAIL Q B4-15
SCALE 0.5X D8-17



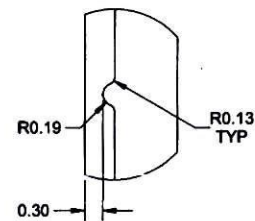
DETAIL U B7-17
SCALE 0.5X D3-17



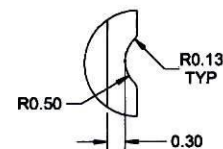
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SCALE 0.5X B4-15



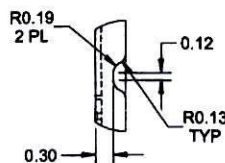
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X C3-10
B2-12



DETAIL S B3-10
SCALE 4X C2-12



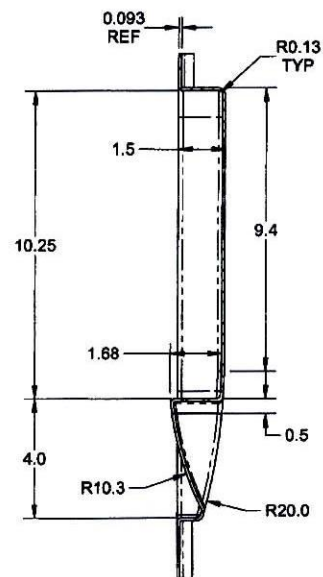
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SCALE 4X

RELEASED

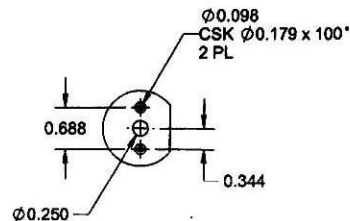
2015 JAN 26

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. G
	MFG. APPR.	DL	D4634	SHEET 17 OF 17
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE		14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

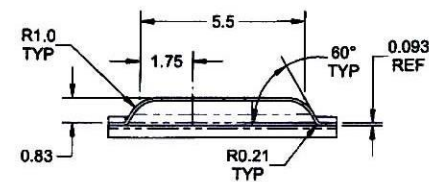
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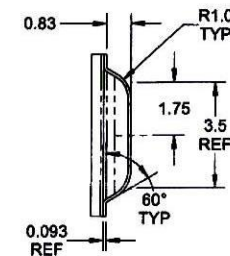
SECTION G-G C5-11
SCALE 4X



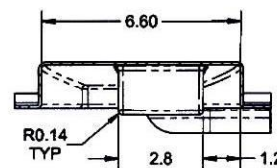
DETAIL C B7-10
SCALE 4X B4-12
B4-14



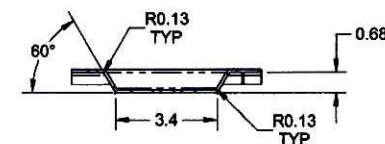
SECTION D-D B6-11
SCALE 2X C4-13
C4-15



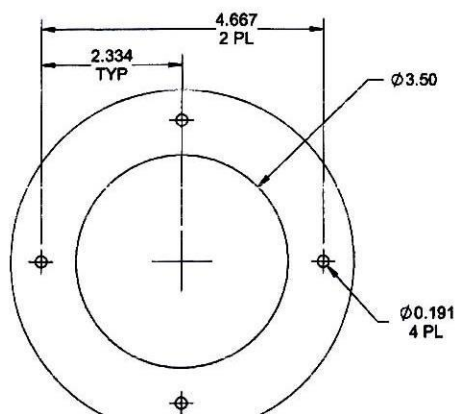
SECTION E-E B5-11
SCALE 4X C4-13
C5-15



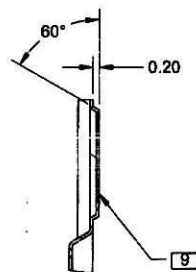
SECTION H-H C5-11
SCALE 2X



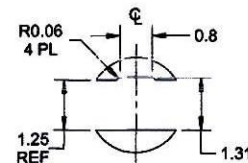
SECTION J-J B6-13
SCALE 2X



DETAIL B B7-10
SCALE 4X
2 PL



DETAIL I B2-13
SCALE 4X C2-13
TYP B2-14
C2-14



DETAIL V C4-10
SCALE 2X B4-12
SIMILAR C4-14

RELEASED

2015 JAN 26

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